

Work Order ID 71152

Thursday, June 23, 2011 12:37:22 PM



Page 1

Item ID: D4039-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Bracket

Start Date: 6/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: YMF

Date: 11-06-23

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4039

B

13SF

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut blank as per file D4039-3_BLANK

60611.X15

B11-7-6

4

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA881 AND DWG

FOLIO REV: B

DWG REV: B

DEBURR

FK 12/06/15

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

FK 12/06/15

4

130

Q.C.B

0.00



QC

Memo

0.00

Quality Control

SL 12-06-15

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12

12 - 6 - 17 (4)

W/O:		WORK ORDER CHANGES					
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Start Date: 6/23/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 4.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Powdercoat Powder Coating M121134	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 Start Time: 8-30 Temp: 320°F Finish Time: 9-00				4X ✓			M-F 12/06/18
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				H ✓			12/6/18
170  Packaging Packaging	Identify as per dwg & Stock Location: 160 Memo	0.00 0.00				(40)			12/6/18

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/6/19

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 12:37:19 PM

Page 1

Work Order ID: 71152

Parent Item: D4039-3

Parent Item Name: Aft Bracket



Start Date: 6/23/2011

Required Date: 7/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: Ipp Rev:A New Issue 09-12-15 JLM Verified By:EC
B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	12.2000	3	12.63158			



6061-T6 Bar 1.00 x 15.00



1811-7-6

Location

Loc Qty

Loc Code

MAT005

12.2

115173

12

117372

0.2

118184

118184

4

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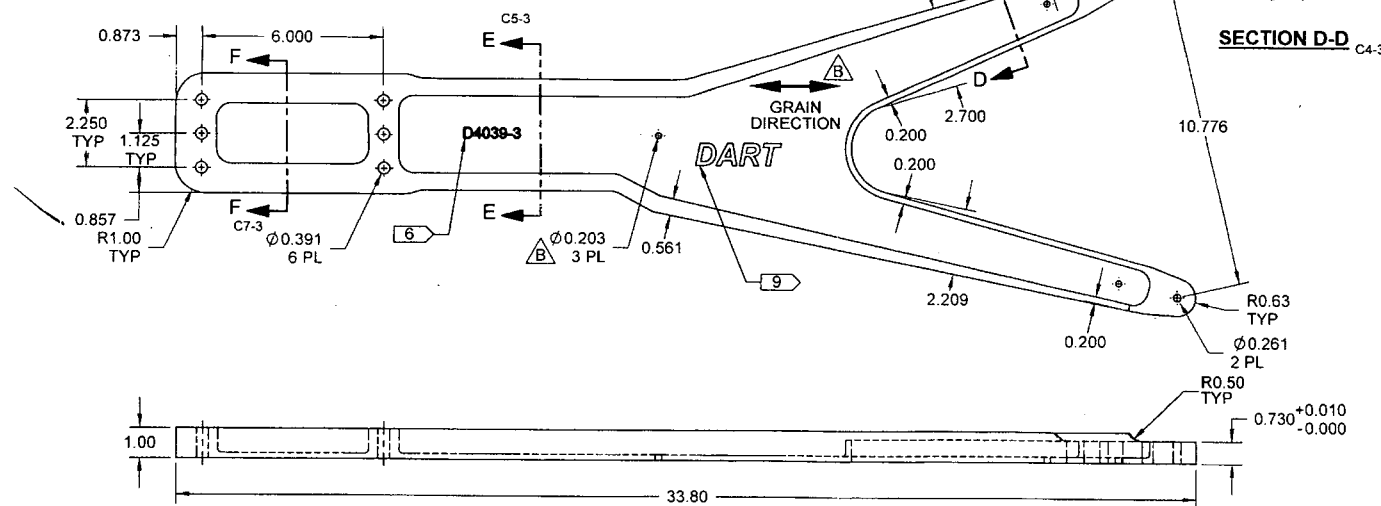
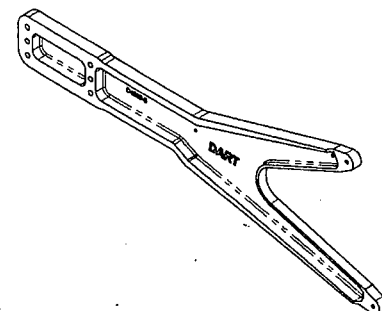
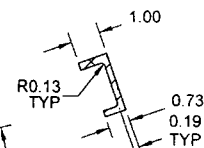
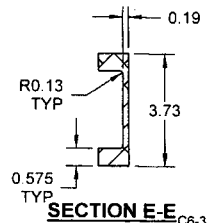
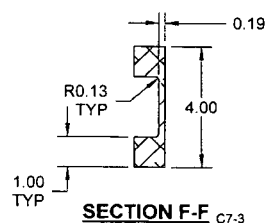
NOTE: Date & initial all entries

8 7 6 5 4 3 2

D

C

B



D4039-3 AFT BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.23 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-3_REV.B.SLDPRT"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250



RELEASED
2010-09-23

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4039	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	10.04.28	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2

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